

SP/it

Work Order ID 51125

August 4, 2009 11:05:21 AM

Page 1

Item ID: D3065-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Step Leg Assembly Hi

Start Date: 8/21/09 Start Qty: 40.00



Cust Item ID:

Required Date: 9/04/09 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: mf Date: 09-08-04 Tooling:

Date:

Run Start



QC: Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3065

Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3065 and Identify as D3065-041

EP 09/08/18 (20)

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

=) S orlosis

counts

(720)

f

120

0.00



Identify as per dwg & Stock Location: WA

Packaging

Memo

0.00

Packaging

SAD 09-08-18

(20x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51125

August 4, 2009 11:05:21 AM

Page 2

Item ID: D3065-041

Accept

Revision ID: B

Item Name: Step Leg Assembly Hi

Start Date: 8/21/09 Start Qty: 40.00

Required Date: 9/04/09 Req'd Qty: 40.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/08/26

PL 09-8-27 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 4, 2009 11:05:20 AM

Work Order ID: 51125

Parent Item: D3065-041RevB

Parent Item Name: Step Leg Assembly Hi

Comments:

Start Date: 8/21/09

Required Date: 9/04/09

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3065-1RevB

Manufactured

No

100

Each

70.0000

40.0000



Step Spacer



EP 09/08/18

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

GA

-20

46333

-20

Main Warehouse

ST

90

46333

39

48113

51

20

D3065-3RevB

Manufactured

No

100

Each

90.0000

40.0000



Step Spacer



EP 09/08/18

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

GA

60

48113

-20

50144

80

Main Warehouse

ST

30

48113

30

20

Picklist Print

August 4, 2009 11:05:20 AM

Work Order ID: 51125

Parent Item: D3065-041RevB

Parent Item Name: Step Leg Assembly Hi


Comments:

Start Date: 8/21/09

Required Date: 9/04/09

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3065-5RevB		Manufactured	No			100	Each	0.0000	80.0000			
												
Step Leg												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

GA

-40

50145

-40

Main Warehouse

ST

40

50145

40

D3065-7RevB

Manufactured

No

100

Each

171.0000

40.0000



Step Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

GA

-20

45395

-20

Main Warehouse

ST

191

44395

34

45395

18

46333

49

48113

50

50146

40

August 4, 2009 11:05:20 AM

Shop Packet Print

Picklist Print

August 4, 2009 11:05:20 AM

Work Order ID: 51125

Parent Item: D3065-041RevB

Parent Item Name: Step Leg Assembly Hi


Comments:

Start Date: 8/21/09

Required Date: 9/04/09

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20470AD4-4		Purchased	No			100	Each	7,162.000	1,200.0000			
												
Rivet, Universal Head												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7162

111359

2162

112314

5000

EP 09/08/18

1000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

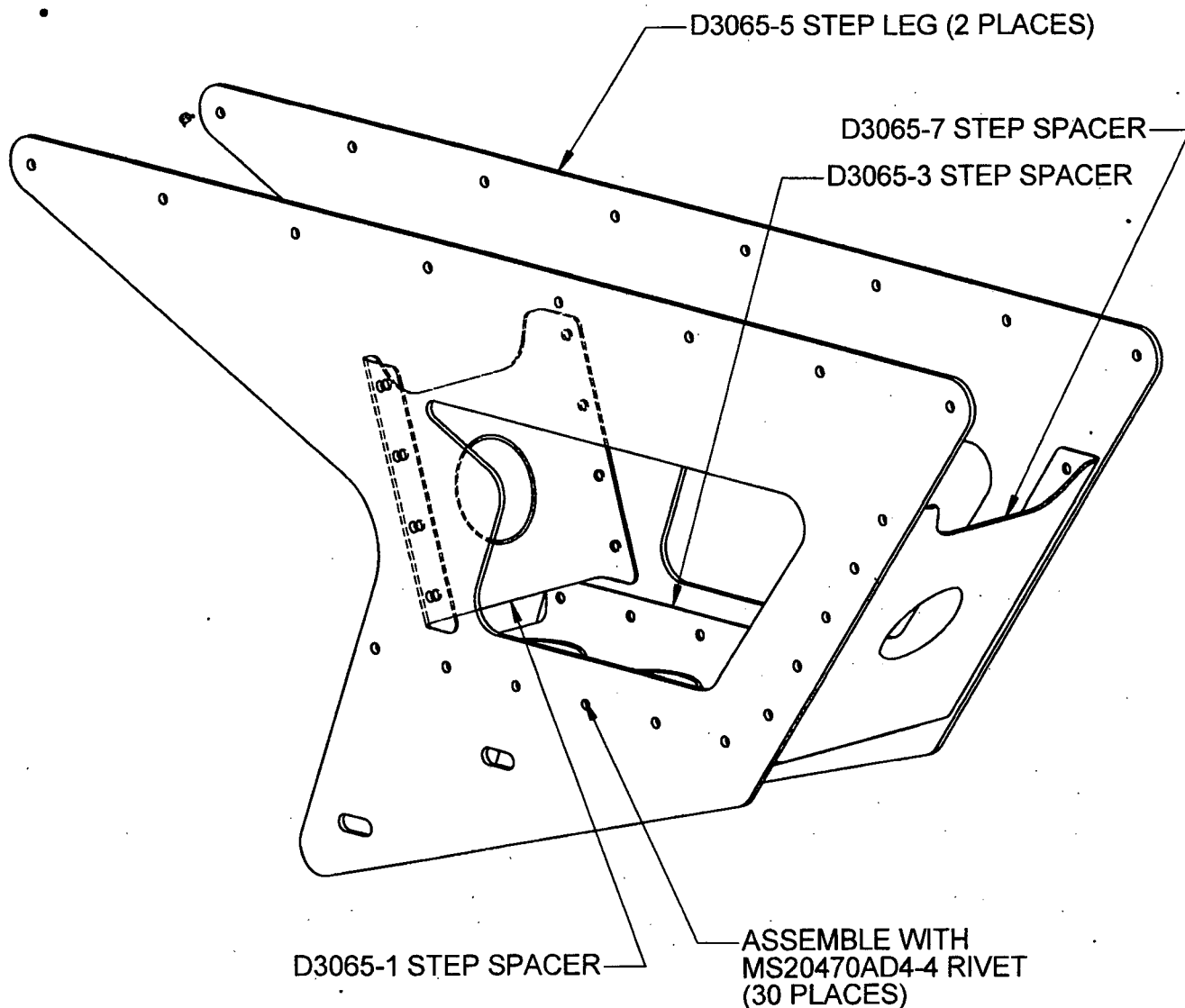


DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*

#51125
MF
09-08-04



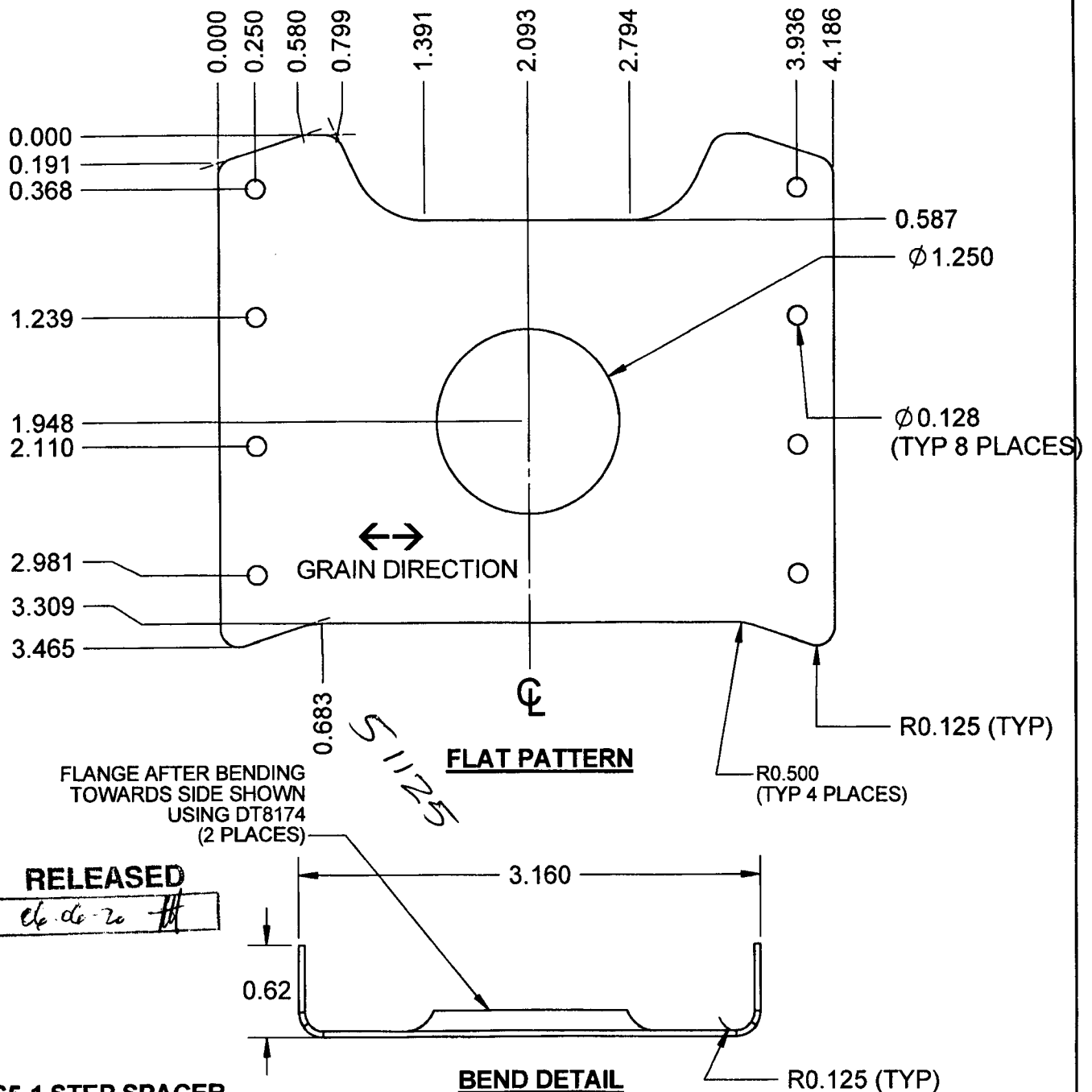
D3065-041 STEP LEG ASSEMBLY

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

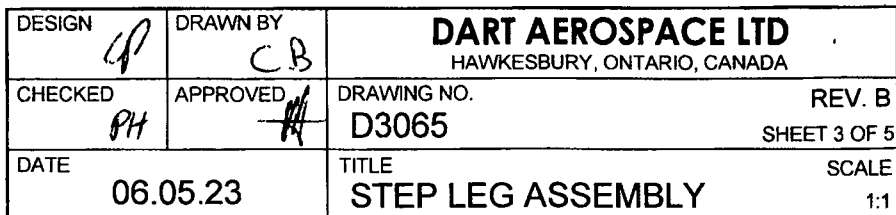


D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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06 de 20 - ~~11~~

51125



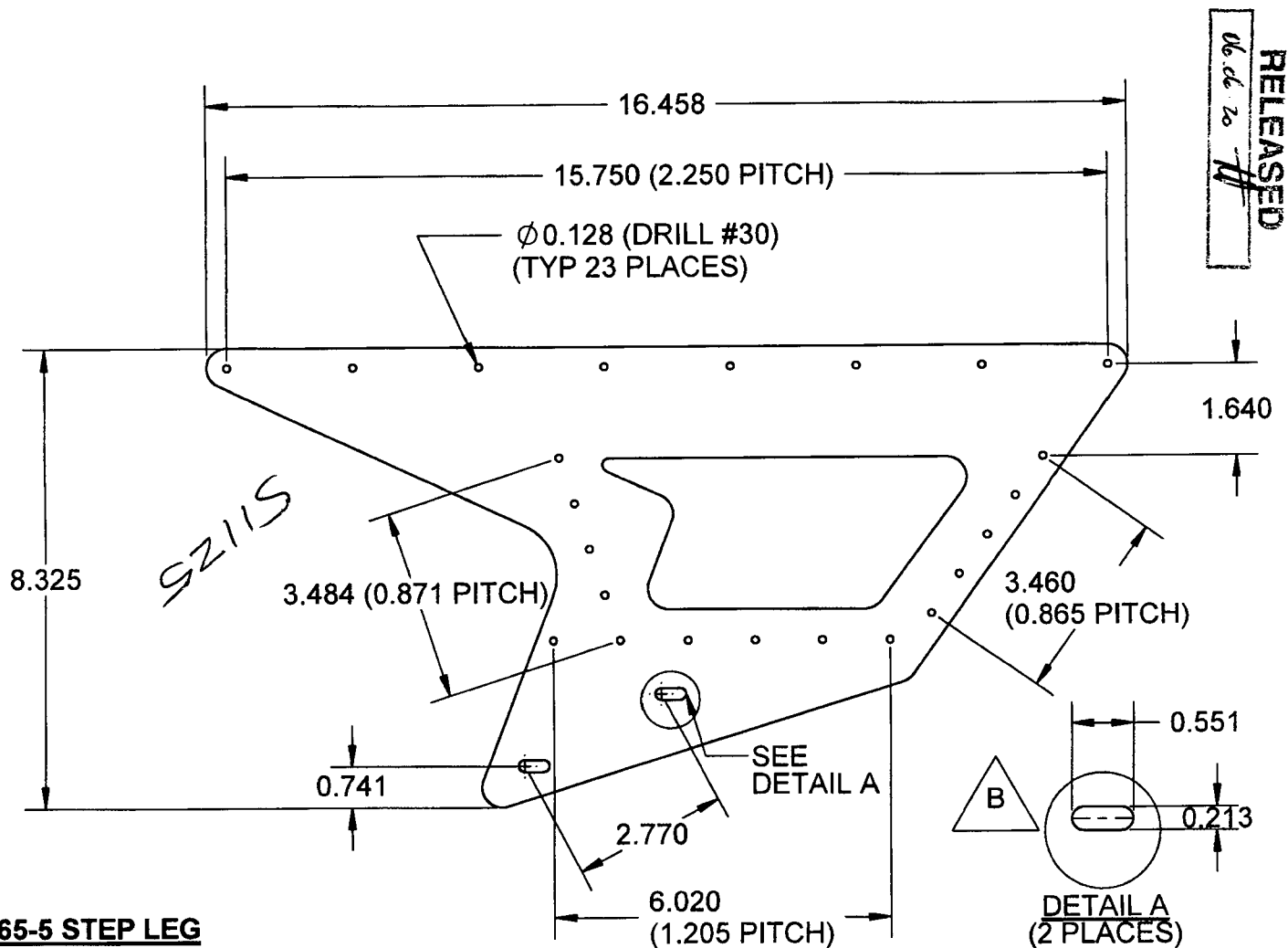
- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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				HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>PH</i>	APPROVED	<i>CB</i>	DRAWING NO.
				D3065
DATE	06.05.23	TITLE	STEP LEG ASSEMBLY	REV. B
		SCALE	1:3	SHEET 4 OF 5



D3065-5 STEP LEG

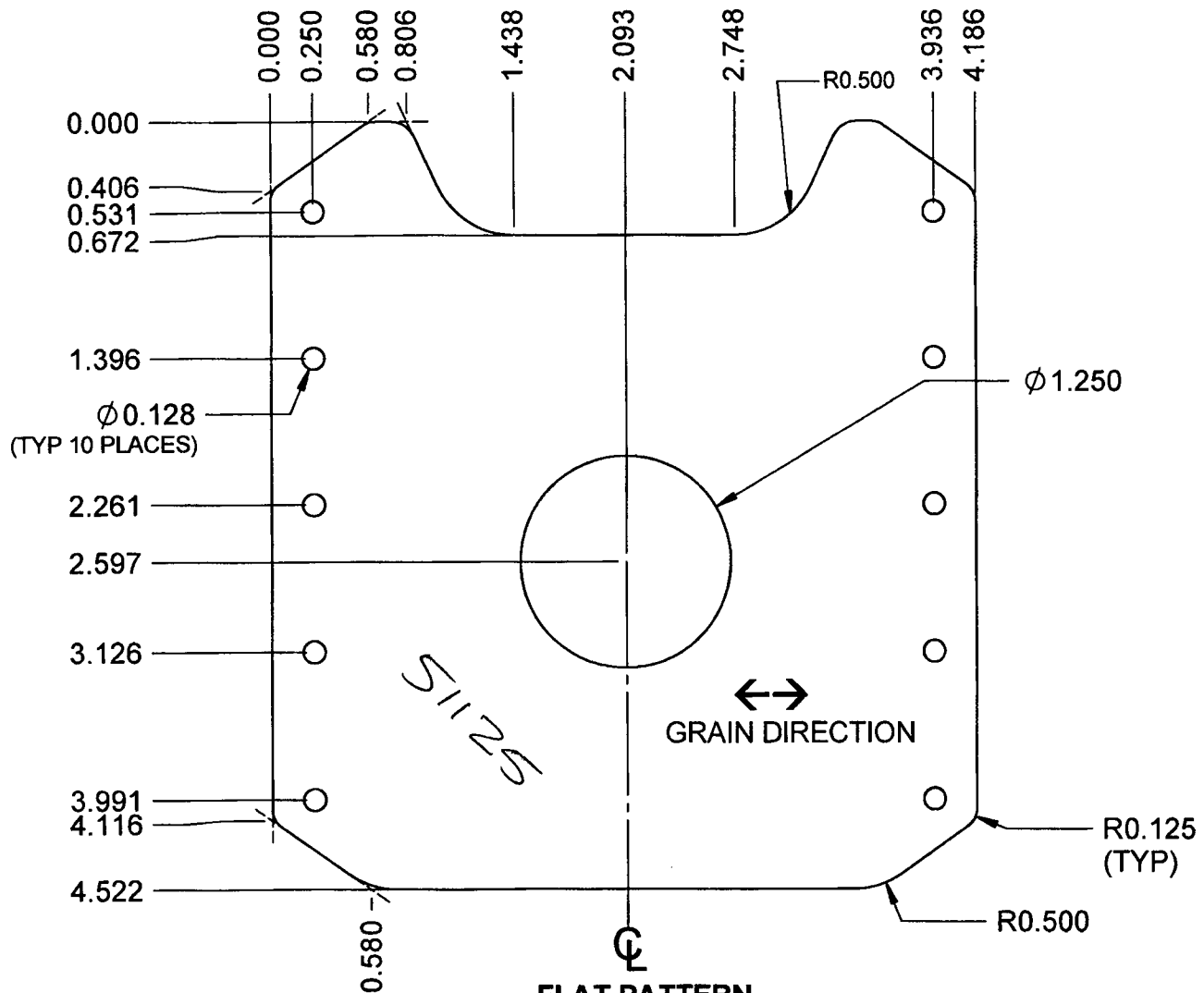
- 1) MACHINE PER DWG FILE "D3065-5.SLDPRJT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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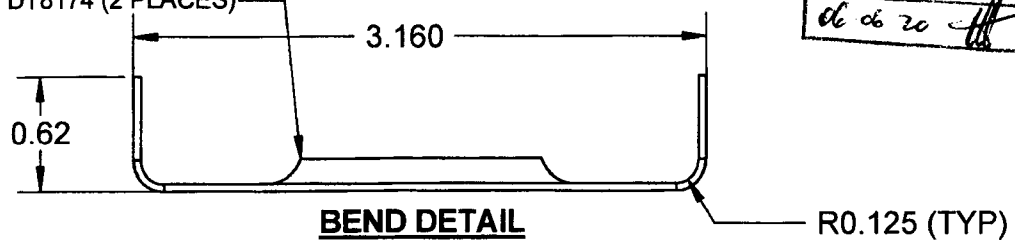
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



FLANGE AFTER BENDING TOWARDS
SIDE SHOWN USING DT8174 (2 PLACES)



D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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